

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012475**Date Inspected:** 10-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Tom Pasqualone**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform the Ultrasonic Testing (UT) of weld joint 1E/2E-A-3 and to perform a random verification inspection.

The following observations were made:

1) Quality Control Tom Pasqualone and Steve McConnell were in the process of performing Ultrasonic Testing on weld joint 1E/2E-A-3.

This QA Inspector was informed by QC personnel Steve McConnell all required scans except for scanning pattern "D", which is used to detect transverse indications had been performed on a previous shift. This QA Inspector randomly observed QC Steve McConnell performing UT scanning which appeared to comply with pattern "D" as specified in AWS D1.5-02, section 6 (Inspection). This QA Inspector was informed by QC Steve McConnell of the following: The area of UT inspection performed was on 5,200 mm of the 5,500 mm full weld length of 1E/2E-A-3. The area inspected by QC was from 220mm to 5,420 mm (0 mm is at the line separating welds 1E/2E-A-2 and A-3). During the UT inspection 2 indications; one measuring 30mm and the other 20mm in length had been rejected and all other areas had been accepted.

Upon confirmation that QC personnel were completed with their UT inspection this QA Inspector performed a random UT verification. The verification was performed at the following locations: The first area was 750 mm in length starting at 3,020 to 3,770 and the second area was 500 mm in length from 4,920 to 5420. The second area

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

included the 2 areas rejected by QC personnel. Overall QA verification was performed on 1,250 mm of weld, which is approximately 25% of the area inspected by QC.

The work observed and the UT verification performed appeared to comply with the contract requirements. Please see Ultrasonic Inspection Report (TL-6027) this date for further details.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig
----------------------	-------------

Quality Assurance Inspector

Reviewed By:	Levell,Bill
---------------------	-------------

QA Reviewer
